

Date: Wednesday, 2/1/2006 11:44:48 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 25709		
Estimate Number	: 11028		
P.O. Number	: N/A	Part Number	: D28022
This Issue	: 2/1/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2802 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: A
	Type : MACHINED PARTS	Material	: N/A
Written By	: <u>See Below</u>	Due Date	: 2/28/2006
Checked & Approved By	: <u>02.02.01</u>	Qty:	8 Um: Each
Comment	: Est:B 02.03.18 Re-format NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5750 f(s)/Unit Total: 12.6000 f(s)  
 6061-T6 Bar .50" x 6.0"  
 Material: 6061-T6 bar 6.00" x 0.50"  
 Batch: M18463

J-F.

06/02/07

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blanks 17.800" long

J-F.

06/02/07

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per folio FA101  
 Counter sink .375 dia as per dwg

J-F.

06/02/08

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J-F.

06/02/08

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 06.02.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *PD*   Date: 06/02/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/1/2006 11:44:48 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 25709

Part Number: D28022

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Tumble & Deburr NO sharp edges.

*Handwritten:* 06.02.14 = 8

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 06.02.14

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*Handwritten:* N/A

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: *Handwritten:* WA-2

*Handwritten:* 06.02.14

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

*Handwritten:* Sat 06/02/15 (8)

*Handwritten:* 06.02.15 (8)

Job Completion



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-02-14	8	<p>powder cast not needed. Stock for welding</p> <p>Remove powder cast.</p> <p>permanent change.</p>	<i>[Signature]</i>	06-02-15		<i>[Signature]</i> 06-02-14	<i>[Signature]</i> 06-02-14

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/02/15

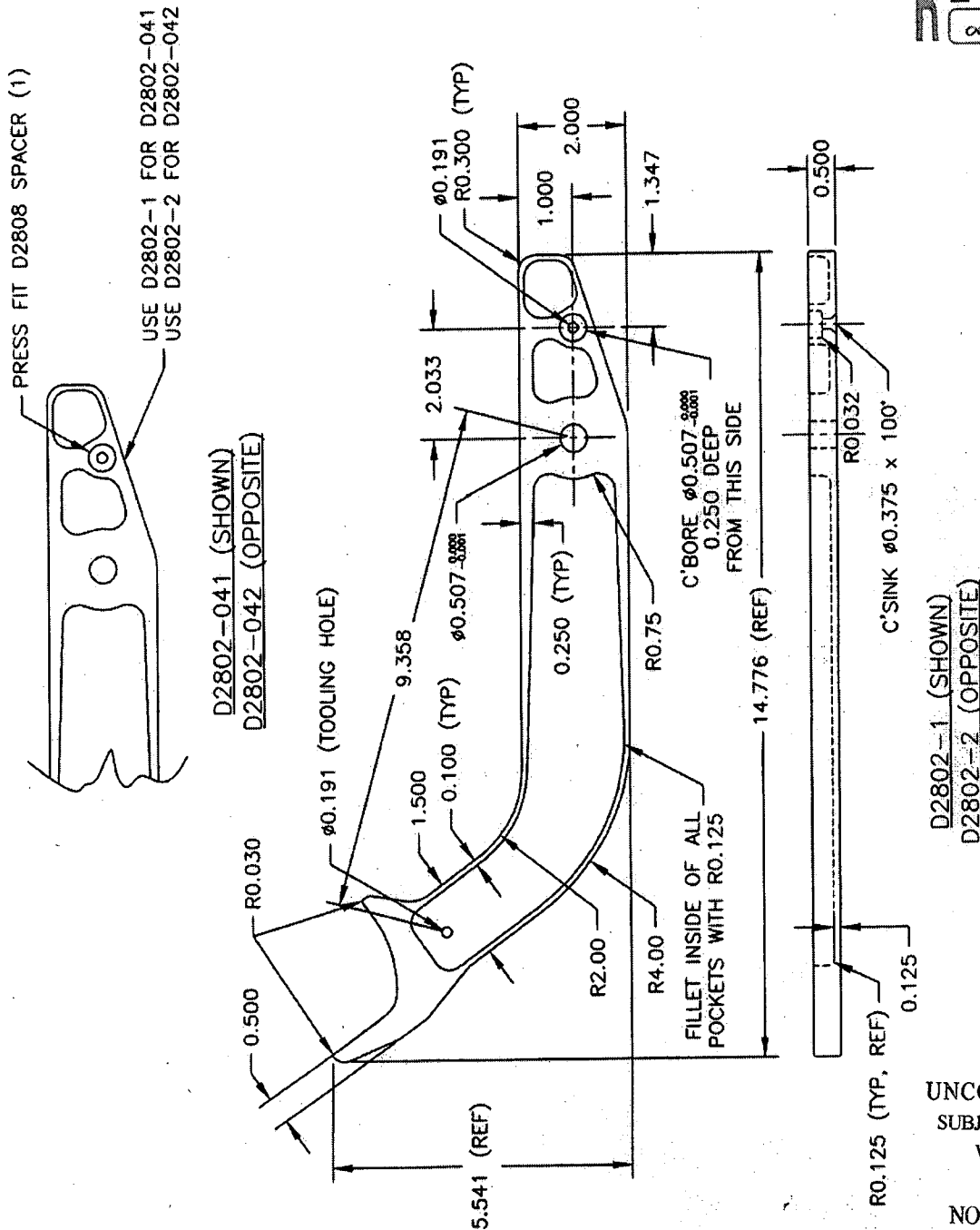
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2802	REV. A SHEET 1 OF 1
DATE 00.11.03	TITLE ARM		SCALE 1:3
A	00.11.03	NEW ISSUE	

**RELEASED**  
00.11.13 #

SHOP PER DRAWING FILE "D2802-A1.DWG"  
RETURN TO  
ENGINEERING  
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)  
DEBORR TO LEAVE R0.030 - 0.063 ON ALL EDGES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25709

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DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0,500		0,497"	/			
0,030 R0		0,030 R0"	/			
0,191 Ø		0,191 Ø"	/			
9,358		9,358"	/			
1,500		1,502"	/			
0,100		0,101"	/			
0,250		0,252"	/			
0,507 Ø		0,506"	/			
2,033		2,035"	/			
0,300 R0		0,300 R0"	/			
1,000"		1,000"	/			
2,000"		2,001"	/			
1,347"		1,347"	/			
0,750 R0		0,750 R0"	/			
4,00 R0		4,00 R0"	/			
2,00 R0		2,00 R0"	/			
5,541		5,545"	/			
0,250 prof		0,246"	/			
14,776		14,780"	/			
0,125		0,1235"	/			
0,500		0,505"	/			

Measured by: J.F.	Audited by: SA	Prototype Approval: N/A
Date: 06/02/08	Date: 06.02.08	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

33  
100